

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022547**Date Inspected:** 07-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island **Location:** Shanghai, China

CWI Name: Mr. AN QIANG XING
Inspected CWI report: Yes No N/A
Electrode to specification: Yes No N/A
Qualified Welders: Yes No N/A
Approved Drawings: Yes No N/A

CWI Present: Yes No
Rod Oven in Use: Yes No N/A
Weld Procedures Followed: Yes No N/A
Verified Joint Fit-up: Yes No N/A
Approved WPS: Yes No N/A
Delayed / Cancelled: Yes No N/A

Bridge No: 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna Pillai was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Trial Assembly Area:

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Base Metal Repair weld (temporary attachment removal area) near the side plate to side plate transverse splice weld joint located on 11CW+11DW at counter weight side. The location near the weld is designated as OBW11C-002. The welder is identified as 062935. ZPMC QC Mr. ZHU YUAN YUAN was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1. The weld repair report number is named as CWR-1842.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the edge plate to deck plate hold back weld joint located on west side of 11DE at bike path side. The

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

weld is designated as CA090-006. The welder is identified as 040320. ZPMC QC Mr. WANG LI YANG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2214-TC-U4b-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the edge plate to edge plate transverse splice weld joint located on 11DW+11EW at cross beam side. The weld is designated as OBW11A-010. The welder is identified as 040611. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2213-B-U2-FCM-1.

ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of Fillet welds joining the T-Rib to side plate hold back weld joint located on 11DW+11EW at cross beam side. The weld is designated as SP785-001-033(11DW) & SP786-001-009(11EW). The welder is identified as 053486. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess FCAW appears to be progressing in compliance with WPS-B-T-2132.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the edge plate to edge plate transverse splice weld joint located on 11DW+11EW at counter weight side. The weld is designated as OBW11A-006. The welder is identified as 044551. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2213-B-U2-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the T-Rib web to web weld joint for side plate located on 11DW+11EW at cross beam side. The weld is designated as SP745-001-043. The welder is identified as 057333. ZPMC QC Mr. ZHU ZHONG HAI was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2213-B-U2-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the I-Rib to I-Rib weld joint for edge plate located on 11CW+11DW at counter weight side. The weld is designated as EP121-001-013 & 014. The welder is identified as 046709. ZPMC QC Mr. ZHU ZHONG HAI was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2214-B-U2-FCM-1.

2. NDT:

Ultrasonic Testing (UT) (A, B, C and D-Scan):

UT not done for the ABF submitted UT Report No UT-11W-052 R1 due to the surface problem. Notification cancelled by ABF Quality Assurance (QA).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Pillai,Santosh	Quality Assurance Inspector
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Reviewed By:	Miller,Mark	QA Reviewer
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